Date: User:

Tuesday, 11/21/2006 1:33:27 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 29609

Estimate Number

: 10383

P.O. Number

: NIA

This Issue Prsht Rev.

: 11/21/2006

: NA

: 29234

s.o. No. : 41m

Type

: SMALL /MED FAB

Part Number

Due Date

Drawing Name

: D30661 : D3066 REV.B

: SPACER

Drawing Number Project Number

: N/A

Drawing Revision Material

: 12/10/2006

Previous Run Written By

First Issue

Checked & Approved By

Comment

Incorporated D3066-1 IPP KJ/RF

Est Rev:B

Now M6061-T6 06-06-23 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M6061T6S080

6061-T6 .080 Sheet



Comment: Qty.:

0.0992 sf(s)/Unit Total:

5.9535 sf(s)

Material: 6061-T6 0.080" thick

(M6061T6S.080)

Batch: M102723 WC 06 11 28

FLOW WATER JET

2.0

WATER JET



Dwg Rev: B



Comment: FLOW WATER JET

1-Cut as per Dwg D3066

2-Deburr if necessary

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

3.0

QC8

SECOND CHECK



Comment: SECOND CHECK



5.0

HAND FINISHING1

HAND FINISHING RESOURCE #

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



Dart Ae	rospace l	Ltd							
W/O:			WC	ORK ORDER CHANGES					
DATE	STEP			NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					1				
			<u> </u>					:	
-		·		·					
Part No	:	PAR #:	Fault Cate	gory: N	7		·		12/05
			WORK ORDI	ER NON-CONFORMANO				Date:	
NCR:					JE (NOI	· · · · · · · · · · · · · · · · · · ·			,
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign &	Verifica Section		Approval Chief Eng	Approval QC Inspector
		:							
•					·				

NOTE: Date & initial all entries

Tuesday, 11/21/2006 1:33:27 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 29609 Part Number: D30661 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WA23 FINAL INSPECTION/W/O RELEASE 8.0 Comment: FINAL INSPECTION/W/O RELEASE CL06/12/05 Job Completion

Dart Aerospace Ltd

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W/O:			WC	ORK ORDER CHANG	ES				· · ·
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ/	A:	Date:	
					QA: N/	C Closed	d:	_ Date: _	
NCR:			WORK ORDI	R NON-CONFORMA	ANCE (NCR)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C	Chief Eng	QC Inspector
						<u></u>			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	29609
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Ar	ticle	Prote	otype
Drawing	Α	ctual	_		Metho

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	Ø0.128	+0.005 -0.000	0.129	/		vern	
	0.708	+/-0.010	0.710	√		VRCN	
<i>i</i> [0.35	+/0.010	0.351	1		1ern	
٦	0.35 4	+/0.010	0.350	1		vern	
Г	2.250 (Pitch)	+/-0.005	2.251	/_		verN	
	16.450	+/0.010	16.450	1		Measuring	tape
							*
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 6 // 29	Date: \$\int_6/1/29	Date:	N/A

ſ	Rev	Date	Change '	Revised by	Approved
Ī	Α	03.09.22	New Issue P/O D3065-041	KJ/RF	1
	В	06.06.23	Dwg Rev. changed	KJ/JLM	411



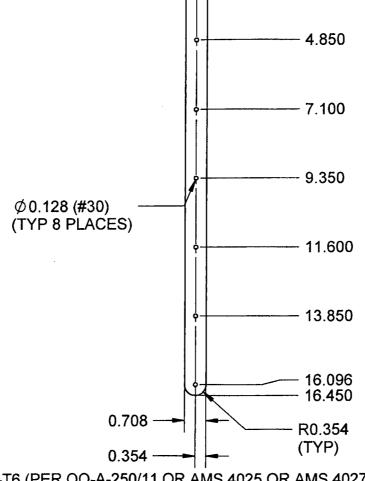
DRAWN BY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA APPROVED___ DRAWING NO. REV. B CHECKED D3066 SHEET 1 OF 1 TITLE DATE **SCALE** 06.05.29 SPACER 1:3 02.09.11 **NEW ISSUE** Α 06.05.29 ADD 6061-T6 MATERIAL В

- 0.000

0.354

2.600

RELEASED



1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S 080)

(REF DART SPEC M6061T6S.080)

RETURN TO

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)

ENGINEERING

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

UNCONTROLLED COPY SUBJECT TO AMENDMENT

3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE WITHOUT NOTICE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 6) ALL DIMENSIONS ARE IN INCHES

D3066-1 SPACER

WORK ORDER

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